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(71) Applicant: MITSUBISHI DENKI KABUSHIKI
KAISHA

2-3, Marunouchi 2-chome Chiyoda-ku
Tokyo(JP)

Applicant: Kakino, Yoshiaki
256-5 Hanazono-cho Iwakura
Sakyo-ku Kyoto-shi Kyoto 606(JP)

Applicant: YASUDA KOGYO K.K.
1160 Hamanaka, Satoshō-cho
Asaguchi-gun, Okayama-Ken(JP)
Applicant: MITUTOYO CORPORATION
31-19, Shiba 5-Chome Minato-Ku

Tokyo(JP)

(72) Inventor: Kakino, Yoshiaki
256-5, Iwakura-Hanazono-cho, Sakyo-ku
Kyoto 606(JP)
Inventor: Tokuno, Shigeaki
9756 Satomi, Satosho
Asaguchi, Okayama(JP)
Inventor: Nakamura, Tetsuo
1-8-15, Kodai, Miyamae
Kawasaki, Kanagawa(JP)
Inventor: Takeshita, Torao, c/o Mitsubishi
Denki K.K. Nayoya
Seisakusho, 1-14, Yadaminami 5-chome,
Higashi-ku
Nagoya-shi, Aichi-ken(JP)

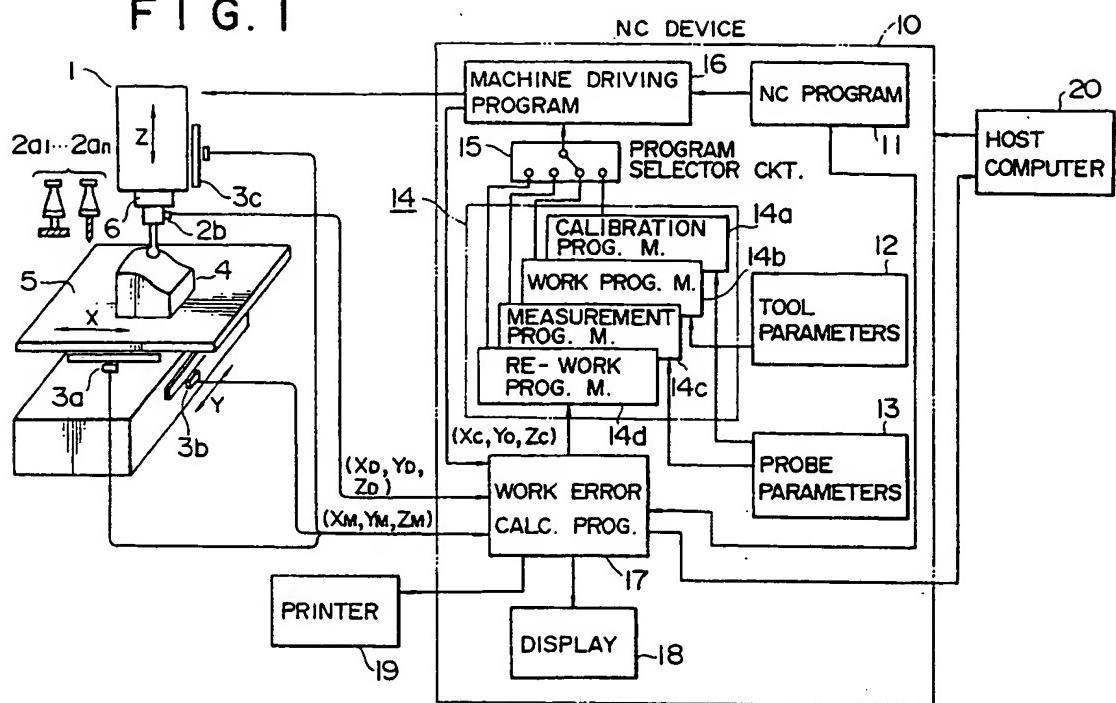
(74) Representative: Sajda, Wolf E., Dipl.-Phys. et
al
MEISSNER, BOLTE & PARTNER
Widenmayerstrasse 48 Postfach 86 06 24
W-8000 München 86(DE)

(54) Numerical control device for a machine tool.

(55) A numerical control (NC) device (10) for a machine tool (1) provided with a measurement probe (2b) effects measurements of the work (4) on the machine table (5) after a working process. The measurement program, generated by the NC device (10) by modifying the working program, controls the relative movement of the probe (2b) with respect to the work (4) such that the probe (2b) moves along the contour of the worked portion of the work (4) with a

displacement from the neutral position thereof, wherein the displacement of the probe (2b) is sampled at a predetermined sampling period. A working error calculation program (17) calculates the working error from the sampled displacements. If the working error is judged correctable, a correction re-working is effected so as to reduce the working error. The measurement/re-working cycles are repeated until the working error is within tolerance.

FIG. 1





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EUROPEAN SEARCH REPORT

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EP 90 12 3255

DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
Y	ATM MESSTECHNISCHE + PRAXIS, vol. 55, no. 9, September 1988, MUNCHEN DE pages 323 - 329; F. DANIELLI: 'Integration von Meßsteuerungen in flexible Fertigungslienien.' * page 323, paragraph 2 *	1-3	G05B19/18
A	J.CHEN AND Y.F. CHEN 'Estimation of coordinate measuring machine error parameters.' 31 March 1987 , IEEE COUNCIL ON ROBOTICS AND AUTOMATION , RALEIGH, NORTH CAROLINA, USA * page 196 - page 201; figure 2 *	1-3	
Y	MANUFACTURING TECHNOLOGY INTERNATIONAL, no. 1, 1988, LONDON GB pages 115 - 116; GUISEPPE CARLO OLIVEI: 'Measurements for flexible manufacturing systems' In-process gauging * page 115 *	1-3	
A	GB-A-2 136 154 (TOKIO KEIKI COMPAGNY LTD.) * abstract; figure 1 *	1-3	TECHNICAL FIELDS SEARCHED (Int. Cl.5) G05B
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	16 JUNE 1992	J.P. Ressenaar	
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X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			